Work Order ID 73396

Wednesday, August 31, 2011 3:04:23 PM

Item ID: D2230-3 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Lug

Start Date: 8/31/2011 **Start Qty:** 200.00 **Cust Item ID:**

Required Date: 9/16/2011 **Req'd Qty:** 200.00 **Customer:**

Reference:

Approvals: **Process Plan:** CL **Date:** 11/08/31 **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2230	Rev G								
100	BAND SAW	0.00							
Bandsaw	**Memo**	0.00							
Jeaspa Bandsaw	Cut D2423 extrusion to 0.82" Batch:_____								
	Cut @ metec								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
HAAS 1 ~~Purch~~	**Memo**	0.00							
HAAS CNC vertical machine #1	1-Machine per folio FA927 FOLIO REV:_____ DWG REV:_____ Check for crack while loading into the machine. 2- deburr								

CL 11/09/01

CL 11/09/01 200

issue P/O to metec P/O: 14799

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 73396

Wednesday, August 31, 2011 3:04:23 PM

Item ID: D2230-3 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Lug

Start Date: 8/31/2011 **Start Qty:** 200.00 **Cust Item ID:**

Required Date: 9/16/2011 **Req'd Qty:** 200.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 rec'd	QC2- ~~Inspect parts off machine~~ FAI/FAIB	0.00							
QC									
Quality Control	**Memo**	0.00							
	rec'd + inspect for transit damage attached cofc to w/o						8/29/23		200
130	QC ~~&~~ Inspect parts - second check	0.00				counts			
QC						~~1000~~			
Quality Control	**Memo**	0.00							
	8/29/23								
150	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish									
Hand Finishing	**Memo**	0.00							
						200 counted	ϕ	8/29/23	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 73396

Wednesday, August 31, 2011 3:04:23 PM

Item ID: D2230-3 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Lug

Start Date: 8/31/2011 **Start Qty:** 200.00 **Cust Item ID:**

Required Date: 9/16/2011 **Req'd Qty:** 200.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
QC	**Memo**	0.00							
Quality Control									
170	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: 2:00 OVEN TEMPERATURE: 320 °F FINISH TIME: 2:30								
180	QC3- Inspect Part Finish	0.00							
QC	**Memo**	0.00							
Quality Control									

200 X Ø M-11/04/26

200 X Ø M-11/04/27

200 BL 11-9-27.

M118439

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 73396

Wednesday, August 31, 2011 3:04:23 PM

Item ID: D2230-3 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Lug

Start Date: 8/31/2011 **Start Qty:** 200.00 **Cust Item ID:**

Required Date: 9/16/2011 **Req'd Qty:** 200.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location ST 480	0.00							
Packaging	**Memo**	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

SP 11-09-28

11/9/28

mr 11-09-28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Wednesday, August 31, 2011 3:04:21 PM

Work Order ID: 73396

Parent Item: D2230-3

Parent Item Name: Lug

Start Date: 8/31/2011 **Required Date:** 9/16/2011

Start Qty: 200.00 **Required Qty:** 200.00

Comments: IPP □D□00.05.18□Added inspection level 8, and removed P/O for powder coat□EC IPP REV :E NEW FOLIO # 10-05-25 JLM VERIFIED BY:EC □

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423		Manufactured	No			100	f	538.5000	0.0683	14.37895			
Lug Extrusion													

Location	Loc Qty	Loc Code
MAT006	538.5	
43722	161.5	
45800	1	
68331	376	

MF 11-09-28

D2230-3 P

X 200

11/5/13 DW

Dart Aerospace Ltd

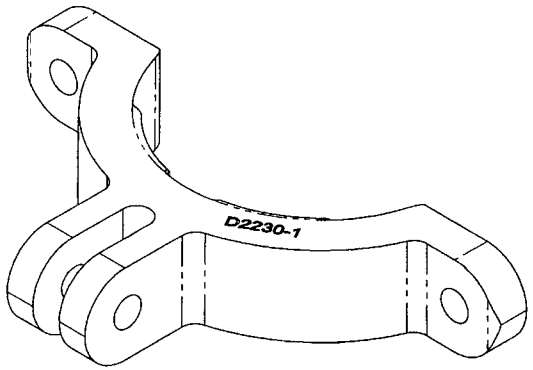
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

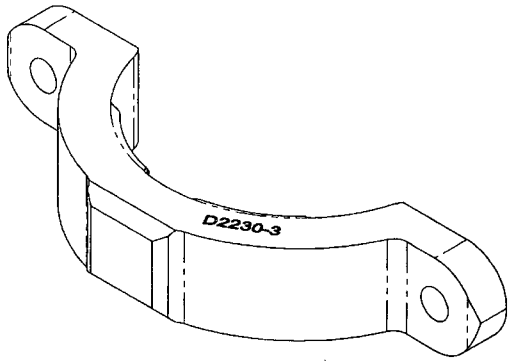
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 73396
CL11108131

RELEASED
09/06/15 MP

△G

NOTES:
1) MATERIAL: MAKE FROM D2423 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ±0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ±0.005.
7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

REV.	DESCRIPTION	BY	DATE
G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN; R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30

DESIGN	BW	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO. D2230 REV. G
MFG. APPR.		SHEET 1 OF 3
APPROVED		TITLE MOUNTING LUG SCALE NTS
DE APPR.		
DATE	09.01.16	

COPYRIGHT © 1994 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD

Dart Aerospace Ltd

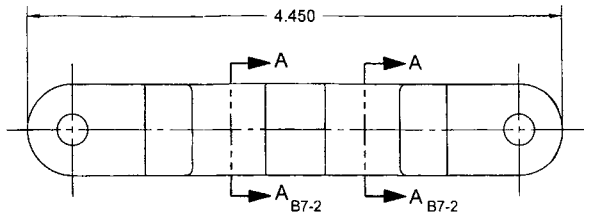
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

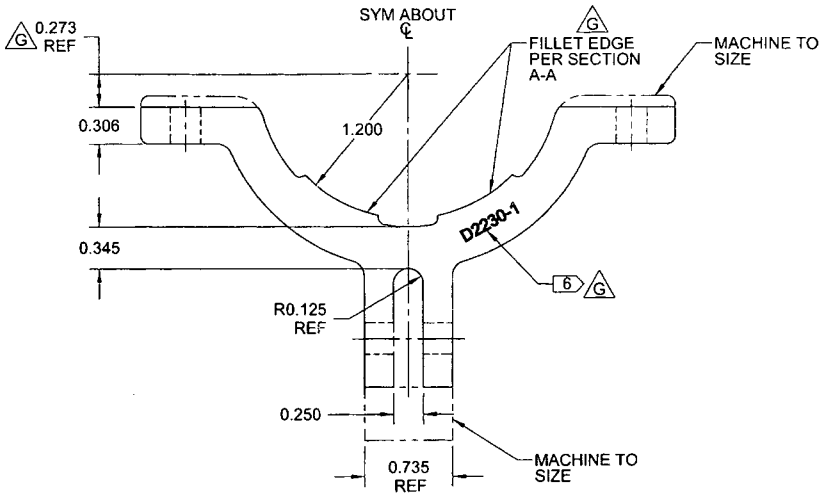
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

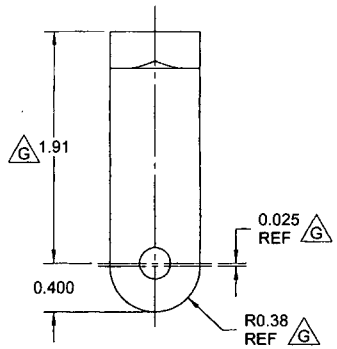
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

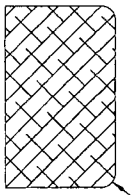
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

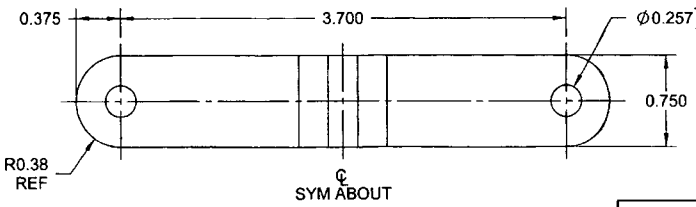








G **SECTION A-A** D4-2
SCALE 2X



D2230-1 MOUNTING LUG

RELEASED
09/06/16

DESIGN	BW	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO. D2230 REV. G
MFG. APPR.		SHEET 2 OF 3
APPROVED		TITLE MOUNTING LUG SCALE NTS
DE APPR.		
DATE	09.01.16	

COPYRIGHT © 1994 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Dart Aerospace Ltd

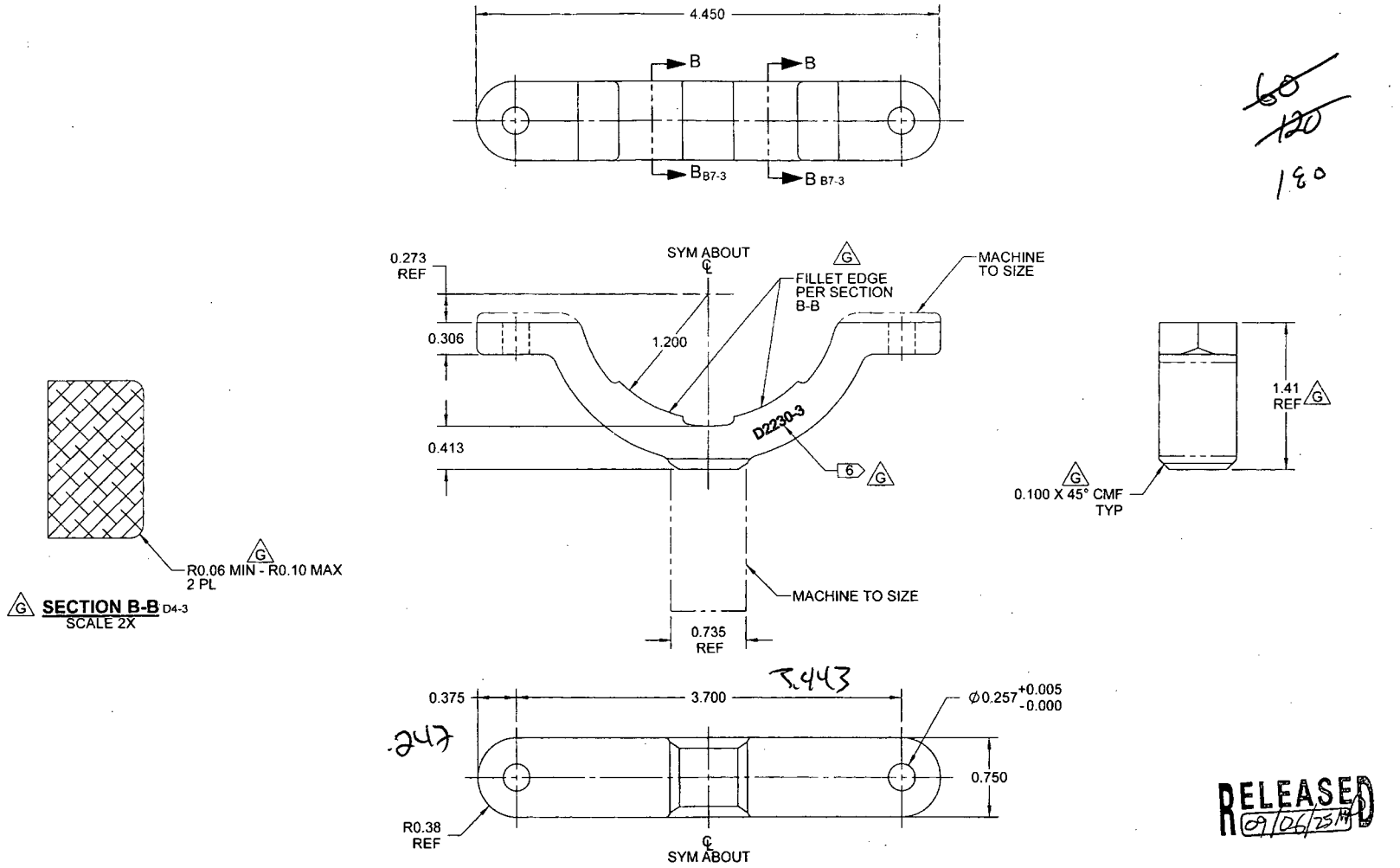
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



D2230-3 MOUNTING LUG

DESIGN	BW	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO. D2230 REV. G
MFG. APPR.		SHEET 3 OF 3
APPROVED		TITLE MOUNTING LUG SCALE NTS
DE APPR.		
DATE 09.01.16		

COPYRIGHT © 1994 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

RELEASED 09/06/23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

METEC METAL TECHNOLOGY INC.

20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: **18201**
Date: Sep 23, 2011
Page: 1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 14799	**Sold By:** Walz, Christian D.
Shipped By: your truck	**Ship Date:**

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2731-3 Mounting Lug Material supplied by DART: D2423 B68331	Each	80		80
D2230-1 Mounting Lug Material supplied by DART: D2423 B68331	Each	100		100
D2230-3 Mounting Lug Material supplied by DART: D2423 B68331	Each	200	200	
D3235-1 Mounting Lug Material supplied by DART: D2423 B68331	Each	100		100
D3394-1 Lug Assembly Material supplied by DART: D2423 B68331	Each	40		
D3910-1 Crosstube Lug Material supplied by DART: D2423 B68331	Each	30		
3910-3 Crosstube Lug Material supplied by DART: D2423 B68331	Each	30		

The delivered goods must be inspected upon receipt to confirm compliance.
Should there be discrepancies please notify METEC within 30 days of delivery.
The goods are otherwise deemed accepted.

Received by _____

Thank you for your order!

METEC METAL TECHNOLOGY INC.

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY	PART NUMBER	PART NAME	P.O. NUMBER
200	D2230-3	Mounting Lug	14799

MATERIAL: supplied by DART D2423 B68331

8 Aug 08/23

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC MetalTechnology Inc.

Shigi Walz

Vankleek Hill, September 23, 2011

20 Terry Fox Drive P.O. Box 781 • Vankleek Hill ON K0B 1R0 • (613) 678-3957 Fax: (613) 678-3956